

**Work Order ID 71384**

Thursday, June 30, 2011 11:40:26 AM



Page 1

Item ID: D3511-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate Assembly

Start Date: 6/30/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 7/5/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

*H*Date: *11-06-30*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3511

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3511 ☐ Dwg Rev: *A* ☐ Prog Rev: *A* ☐ 2-  
Deburr if necessary ☐ Identify as D3511-1*304 .189**B11-7-13**(8)*

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*B11-7-13*

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

*8/12/14**(48)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Brake NC Brake NC	Small Fab  Memo Bend fwd 90 deg. per dwg D3511	0.00  0.00		SB 11/07/15		(8)			
140  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00		S 11/07/15		(x8)			
150  Large Fab Large Fab	Weld per dwg A/R S.S. rod Batch: <u>M1124509</u> Large Fab  Memo weld cups as per dwg	0.00  0.00				x8		11-08-16 JBL/EL	

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Cust Item ID:

Required Date: 7/5/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

155



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

Pl 11.08.17

160



Small Fab

Small Fab

Small Fab

Memo

Form as per Dwg D3511

0.00

0.00

SB 11/6/24

(8)

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Suloe/24

(49)

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 7/5/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

10:00

OVEN TEMPERATURE:

10:30

FINISH TIME:

3200

200

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

210

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

8X ✓ M/11/08/25

8 BR 11-8-25.

11/8/25 SP 80

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/8/26 [Signature]

CL 11108126

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Thursday, June 30, 2011 11:40:32 AM

Page 1

Work Order ID: 71384

Parent Item: D3511-041

Parent Item Name: Wearplate Assembly

Start Date: 6/30/2011

Required Date: 7/5/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 06-05-04 JLM  
IPP Rev:B New process 06-05-05 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S188

Purchased

No

100

sf

35.0000

1.484

12.49684



304 SHEET 0.188



B11-7-13

Location

Loc Qty

Loc Code

MAT020

35

113161

3

113216

32

13216

D3503-1

Manufactured

No

150

Each

16.0000

8

64



Cup



Location

Loc Qty

Loc Code

WA030

16

53788

16

71843

68

11-08-16 x 16 JBL

11-08-16 x 16 JBL

53  
6-30

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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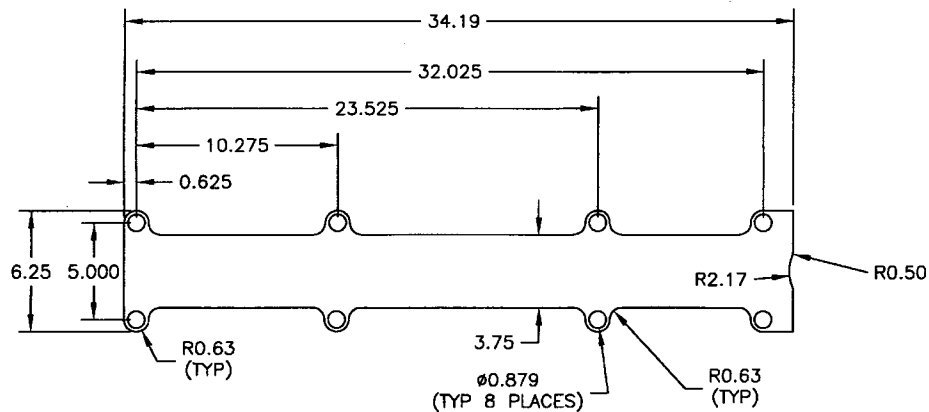
W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

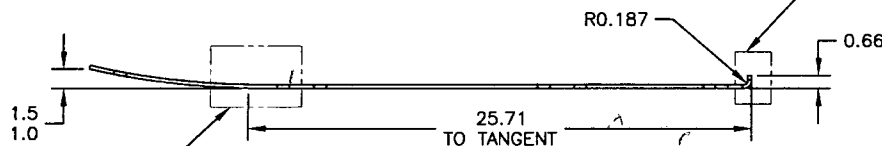
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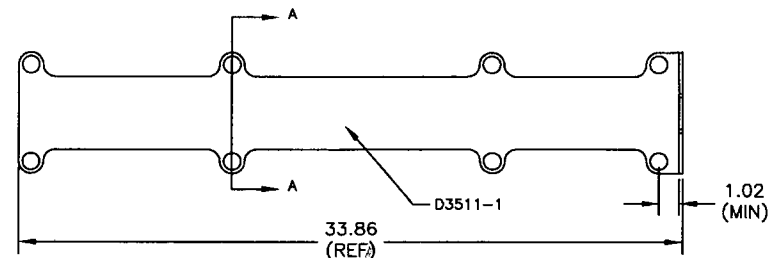
**D3511-1F FLAT PATTERN**

NOTE: BEND BEFORE WELDING



**D3511-1 BEND DETAIL**

NOTE: BEND AFTER WELDING



**SECTION A-A**

**D3511-041 WELD DETAIL**

**D3511-041 WEARPLATE ASSEMBLY**

- 1) MAKE D3511-1F WEARPLATE FROM: AISI 304/316 STAINLESS STEEL (0.188 THICK)  
(REF DART MATERIAL SPEC. M304S7GA)
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT ASSEMBLY BLACK SANDTEX (REF. 4.3.5.7) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3511-041 WEARPLATE ASSEMBLY PARTS LIST**

QTY -041	PART NUMBER	DESCRIPTION
X	D3511-041	WEARPLATE ASSEMBLY
1	D3511-1	WEARPLATE
8	D3503-1	CUP

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER

NO. 71384

*PH 11-04-30*

RELEASED

06 04 25

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A	06.04.04	NEW ISSUE
DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	<b>DART</b> DART AEROSPACE LTD. HAMMERSLEY, OXFORD, CANADA
CHECKED <i>JH</i>	APPROVED <i>JH</i>	DRAWING NO. D3511
DATE 06.04.04	TITLE WEARPLATE	REV. A SHEET 1 OF 1 SCALE NTS

W/O:		WORK ORDER CHANGES					
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